

Work Order ID 85561

85561

Page 1

June-11-12 9:03:32 AM

Item ID: D1038-58B

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fastener Rail, Black

Stop ***NS2***

Start Date: 11/06/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D1038	Rev B								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Create white labels and bag them								
110		0.00							
110	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut extrusion D2023 to length 21.81" (+0.06/-0.00)								
120		0.00							
120	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA783 Rev: <u>AA</u> & Dwg D1038 Rev: <u>B</u> 2-Deburr per dwg D1038								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC2- Inspect parts off machine FAI/FAIB	0.00		12-06-15		50	0		
130									
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00		12/06/14		50	0		
140									
QC	Memo	0.00							
Quality Control									
150	Small Fab	0.00				50			
150									
Small Fab	Memo	0.00							
Small Fab	Deburr								

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Outsource process-Anodize per QSI017 4.1.10.1

0.00

170

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O: 17367
Black Anodize as per Dwg D1038

180

Receive & Inspect for Damage & Mat'l Certs

0.00

180

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***


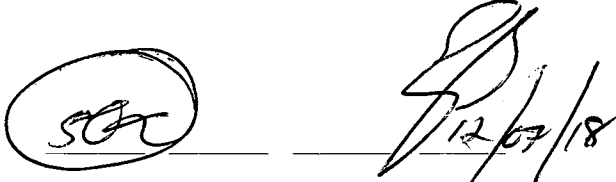


QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		12/07/16					
200 *200* Small Fab Small Fab	Small Fab Memo 1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389 Batch: <u>M120438</u> 2-Grind wire flush and deburr 3-Clean	0.00 0.00							
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		12/07/16					

W/O:		WORK ORDER CHANGES					
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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Packaging	0.00							
220									
Packaging	Memo	0.00							
Packaging	1-Pack each fastener rail into a cardboard tube								
	2-Roll Part in foam .								
	3-Install red cap at each end and secure with tape.								
	4-Apply white labels to cardboard tubes								
	5-Identify and Stock								
	Location: <u>32</u>								
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.00							
Quality Control									

12/8/17

MW 12608107

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

June-11-12 9:03:38 AM

Page 1

Work Order ID: 85561

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Parent Item: D1038-58B

D1038-58B

Parent Item Name: Fastener Rail, Black

Start Date: 11/06/2012

Required Date: 05/07/2012

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP: E 03.05.02 Reformat; Added label KJ/RF
 IPP Rev:F 06-08-16 Updated Packaging Procedures JLM
 IPP Rev:G 08-09-16 Added Folio # JLM Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2023		Manufactured	No			110	f	1,031.570	1.903	95.15			

D2023

Extrusion, Fastener Rail

**

12-06-14

Location

MAT006

21907

Loc Qty

1031.57

1031.57

Loc Code

95.2

W/O:		WORK ORDER CHANGES					
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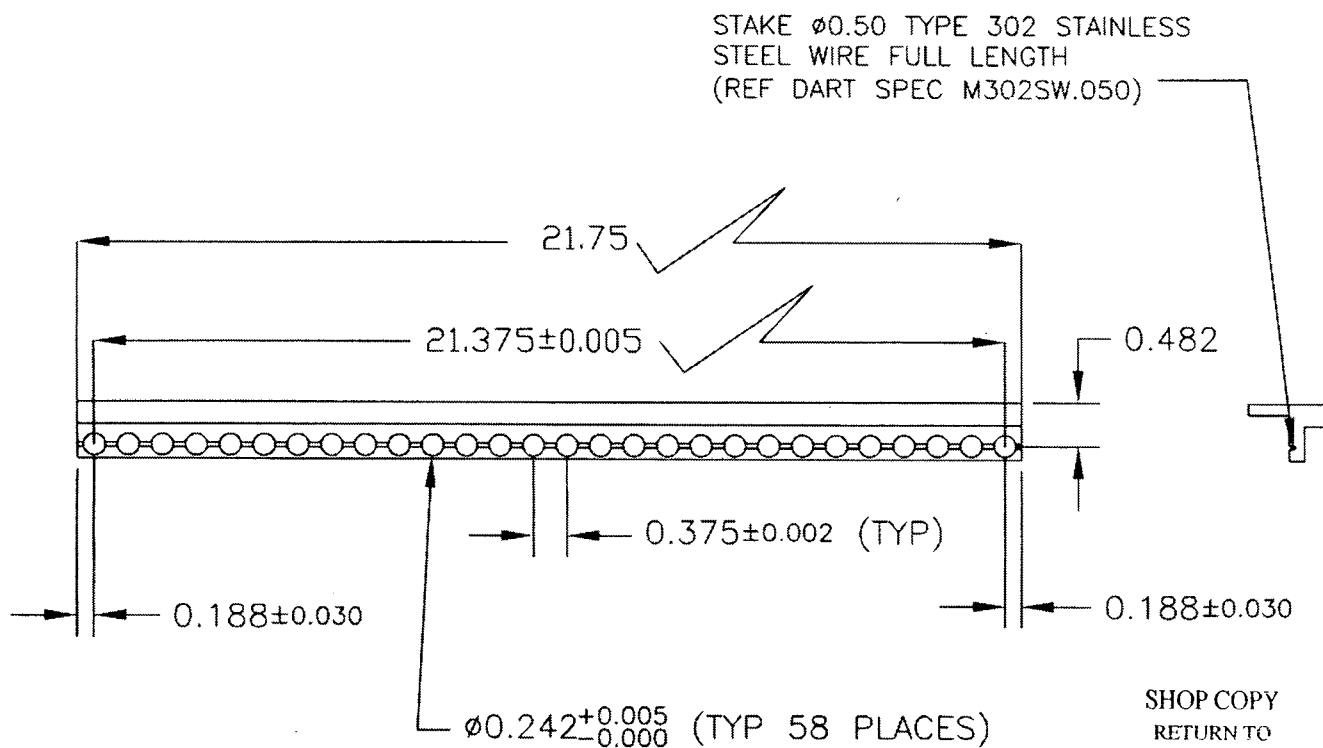
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DART

RELEASED

05.03.31



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85561 MJS
12/06/11

D1038-58 1/4 TURN FASTENER RAIL

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
94	94	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
94	94	D1038	
DATE	TITLE	SCALE	
05.02.02	1/4 TURN FASTENER RAIL	NTS	
-	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17367

Purchase Order Date 7/05/12

PO Print Date 7/05/12

Page Number 1 of 1

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Contact Name

Vendor Phone

613-446-4544

Vendor Fax

613-446-4556

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	85561	D1038-58B RAIL	7/11/12 Yes	50.00	Yours ppd	\$1.8000	\$90.00

Special Inst: ANODIZE AS PER MIL-A-8625F TYPE
I/IB
IC OR II OR IIB CLASS 2
BLACK ANODIZING

PO Total:

\$90.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date:

7/05/12

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required YES NO



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 61817

Date: 12-Jul-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	Line:
50 ea	Part: D1038-58B RAIL BLACK ANODIZE MIL-A-8625 TYPE 2 CLASS 2 Job: 2010389	DAS 16 9-89 17/4/16	PO: PO17367
<p>Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p>ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE : 12/7/12</p> <p>CERTIFIED SIGNATURE : </p> <p>RECEIVER SIGNATURE : _____</p>			